Monday, 6/12/2006 2:35:12 PM Kirn Johnston User: **Process Sheet** : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER Customer Job Number : 27526 : 10383 **Estimate Number** : NIA Part Number : D30661 P.O. Number S.O. No. : NIA : D3066 REV. A : 6/12/2006 **Drawing Number** This Issue : NC : N/A Project Number Prsht Rev. : NIA : MACHINED PARTS Type **Drawing Revision** First Issue :NIA : 27444 Previous Run Material Due Date : 6/19/2006 Qty: Um: Each Written By Checked & Approved By Incorporated D3066-1 IPP KJ/RF Comment **Additional Product** Job Number: Machine Or Operation: Seq. #: Description: M6061T6S080 6061-T6 .080 Sheet 1.0 ,063 -screp 49613 st Comment: Qty.: 4.9613 sf(s) 0.0992 sf(s)/Unit Total: Material: 6061-T6 0.080" thick (M6061T6S.080) WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev:\_\_ Prog Rev: 49 H.M 06-06-15 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 SECOND CHECK Comment: SECOND CHECK INSPECT WORK TO CURRENT STEP Comment: JMSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	Approval	Approval				
DATE	STEP	Section A	Initial Action Description Design Mgr Design Mgr		Sign & Date	Sign & Section C		QC Inspector				
O6 06.14	2	Most 1 is .060 thick. Dwg required. 080 GOG/TG or 5052.	Overs	Scrop destrue : veptoce, with .080	MM 4 6 14	(6:0614	Ban	06-06-14				
(bodo 15	2	19ant Scrape Matilorder tol. Avond I have due to water jet blow out.	Doney	Scrapi desticas	MF.	01.0615	100 mgs	6,0015				
		<b>ν</b>	·									

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:	<u>†</u>
NOTE: Date & initial all entries				QA:	N/C C	losed:	Date:	7

Monday, 6/12/2006 2:35:12 PM Date: Kim Johnston User: **Process Sheet Drawing Name: SPACER** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27526 Part Number: D30661 Job Number: Machine Or Operation: Seq. #: Description: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT CHEMICAL CONVERSION COAT 106 15 PACKAGING RESOURGE #1 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WA 18 DOCUMENT CONTROL 9.0 DÇ Comment: DOCUMENT CONTROL 36/06/16 Inspection Level 21 Job Completion

Dart A	erospace	e Lta							
W/O:		· · · · · · · · · · · · · · · · · · ·	WC	ORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE By				By Date	e Qty	Approval Mfg / Design Mgr	Approval QC Inspector
. ·-									
7									
			WODK ODDI	TO NON CONTORMANO					
NCR:			WORK ORDI	ER NON-CONFORMANC	E (NCF	<b>(</b> )			
DATE	OTED	Description of NC		Corrective Action Section B		Verific	ration	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mar					Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval						
DATE	STEP	Section A	<b>Initial</b> Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspector				
		L		1	1		1	1				

Part No:	PAR #:	Fault Category:	_ NCR:	Yes	No	DQA:	Date:	ý –
NOTE: Date & initial all entries				QA: I	N/C C	losed:	Date:	

D3065-5DART AEROSPACE LTD Work Order: 27526

Description: Spacer Part Number: D3066-1

Inspection Dwg: D3066 Rev: A Page 1 of 1

	FI	RST ARTICLE	INSPEC	TION CH	ECKLIST		
		X First A	rticle [	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Coi	nments
Ø0.128	+0.005	0.131	V		vern vern		
0.708	+/-0.010	0.713	V.		vern		
0.358	+/0.010	0.35%			Vern		
0.350	+/0.010	0.349			vern		
2.250 (Pitch)	+/-0.005	2.247			verh		
16.450	+/0.010	16.450	V		MUMSURING	tope	
Measured by:	M.M	Audited by	:		Prototype Ap	proval:	N/A
Date:	06.06.12	Date	:			Date:	N/A
Rev Date	Change				B	levised by	Approve

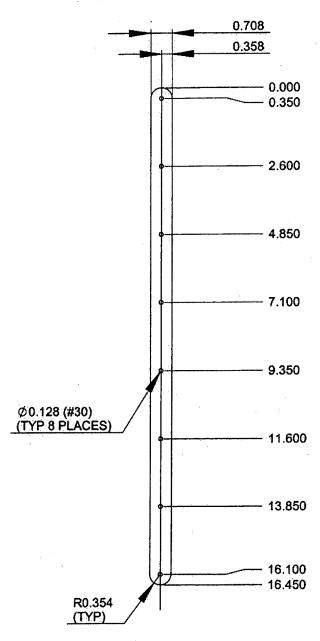
Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	P/O D3065-041	KJ/RF	4-

\_ 1



		turi 1	A Company of the Comp	
DESIG	iap	DRAWN BY	DART AERO: HAWKESBURY, ON	
CHECK	<b>5P</b>	APPROMED	DRAWING NO.	REV. A
'	#-	#	D3066	SHEET 1 OF 1
DATE			TITLE	SCALE
	02.09.11		SPACER	1:3
A	02	2.09.11	NEW ISSUE	





SHOP COPY

RETURN TO

**ENGINEERING** 

**D3066-1 SPACER** 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)OPY
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
without Notice

4) PART IS SYMMETRIC ABOUT CENTERLINE 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD	Work Order: 21526
Description:	Part Number: 3066-1
Inspection Dwg: , Rev:	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.128	+0.005 -0.000	0.130	J.		Yern	
0.708	+1-0.010	0.711	<u> </u>		YerN	
0.358	41-0.010	0.358	√		VerN	
0.350	+1-0.010	0.351	<b>√</b>		Vern	
2. 250 6itch	H. 0.005	2.248	1		VerN	
16.450	+1-0.010	16.450	1		Mensuring	tape
						·
LOUIS NO.						
					,	

			$\Delta$		
Measured by:	M.M	Audited by:		Prototype Approval:	
Date:	06 06 14	Date:	06-06-15	Date:	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	